

Date: Monday, 11/27/2006 10:05:29 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Job Number	: 29700		
Estimate Number	: 10280		
P.O. Number	: N/A	Part Number	: D3137043
This Issue	: 11/27/2006 S.O. No. : N/A	Drawing Number	: D3137 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: E
Previous Run	: 29399	Material	: N/A
Written By	: <u>JA</u>	Due Date	: 12/20/2006
Checked & Approved By	: <u>JA 06 11 27</u>	Qty:	4 Um: Each
Comment	: Est Rev: A 04.02.18 New issue KJ/DS		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174B0500X02000	17-4 SS Bar
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Comment: Qty.: 0.4875 f(s)/Unit Total : 1.9501 f(s)
 Material: 17-4 SS Bar per AMS 5604/5643
 (M17-4-B0.500x02.000)
 Identify for D3137-7
 Batch: M103089 *Be batch number not in COSS*

2.0	* BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: (.500" x 2.000") 5.570" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3137-7 as per Folio FA3308 and Dwg D3137 Identify as D3137-7

2-Deburr

3-Scribe batch number



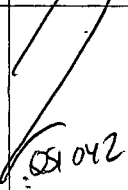

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3137043 PAR #: N/A Fault Category: Prod / Machined Parts NCR: Yes No DQA: SD Date: 07/02/05
 QA: N/C Closed: HJ Date: 07.02.05

NCR: 29700		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/05	30	tool broke while machining		- cannot relocate part in jig. Scrap, destroy Replace	SD 07/01/05			

NOTE: Date & initial all entries

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Drawing Name: BRACKET ASSEMBLY

Job Number: 29700

Part Number: D3137043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Sn 0710123 x (4)

6.0

D31373

Guide



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3137-3

GUIDE

B 28149

MF. 07-01-31

7.0

D31375

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3137-5

Washer

B 2724 x 2mm, B28632 x 2mm

MF. 07-01-31

8.0

MS24694S101

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS24694-s101

Screw

M16941

MF. 07-01-31

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3137-043 as per Dwg D3137

MF. 07-01-31

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/01/31

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

STY10

PC 7/2/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/27/2006 10:05:29 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 29700

Part Number: D3137043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



40

Comment: FINAL INSPECTION/W/O RELEASE

07/02/05

Job Completion



U 07.02.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29700
Description: Bracket		Part Number:	D3137-7
Inspection Dwg: D3137	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.435	+/-0.010	0.434	✓			
0.615	+/-0.010	0.619	✓			
0.200	+/-0.010	0.201	✓			
0.380	+/-0.010	0.385	✓			
0.262	+/-0.010	0.262	✓			
Ø0.500	+0.005/-0.000	Ø0.504	✓			
0.79	+/-0.030	0.795	✓			
2.79	+/-0.030	2.760	✓			
Ø0.560	+0.005/-0.000	Ø0.565	✓			
0.595	+/-0.010	0.595	✓			
0.950	+/-0.010	0.945	✓			
0.605	+/-0.010	0.605	✓			
1.880	+/-0.010	1.881	✓			
2.48	+/-0.030	2.486	✓			
4.975	+/-0.010	4.975	✓			
5.41	+/-0.030	5.412	✓			
0.032	+/-0.010	0.027	✓			
0.063	+/-0.010	0.064	✓			
R0.062	+/-0.010	R0.062	✓			
0.162	+/-0.010	0.157	✓			

Measured by:	gml	Audited by:	MS	Prototype Approval:	N/A
Date:	07/01/17	Date:	07/01/17	Date:	N/A

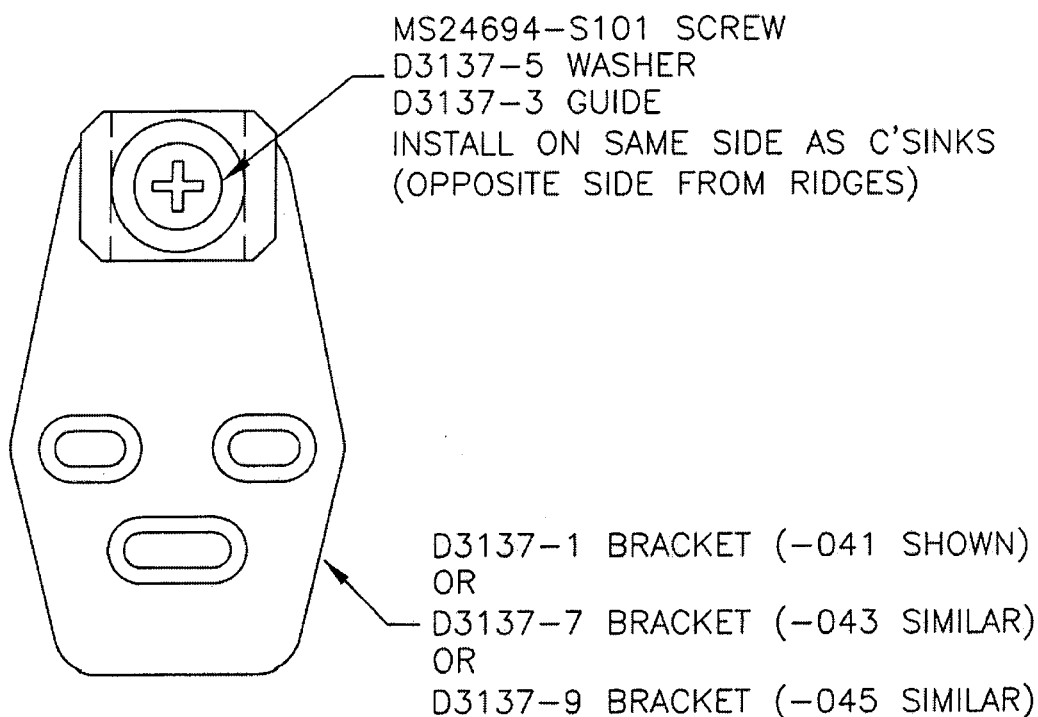
Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3137-043	KJ/RF	
B	04.06.15	Changed & added dimensions	KJ/JLM	
C	06.03.15	Dwg Rev update	KJ/JLM	



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CHECKED #	APPROVED #	DRAWING NO. D3137	REV. E SHEET 1 OF 5
DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 1:1
A	02.04.17	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP.	
C	03.08.15	ADD -043	
D	04.11.03	RE-DESIGN D3137-5; CHANGE DIMS	
E	05.11.23	ADD -045	

RELEASED

05.12.09

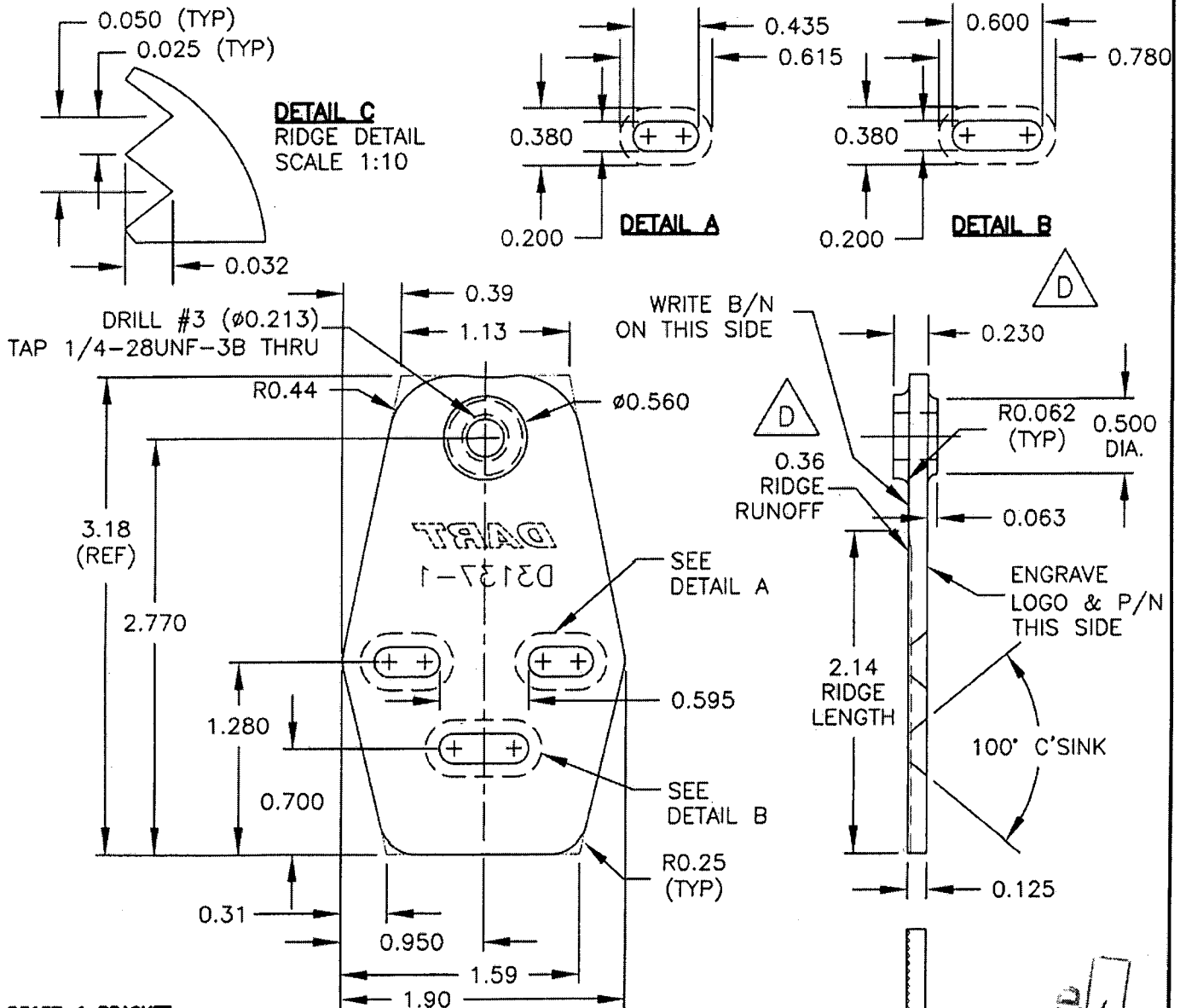
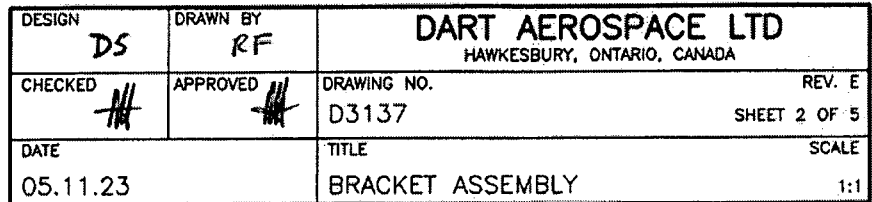


D3137-041 BRACKET ASSEMBLY (SHOWN)
D3137-043 BRACKET ASSEMBLY (SIMILAR)
D3137-045 BRACKET ASSEMBLY (SIMILAR)

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- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
- 2) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANET INK MARKER



SEE DETAIL C

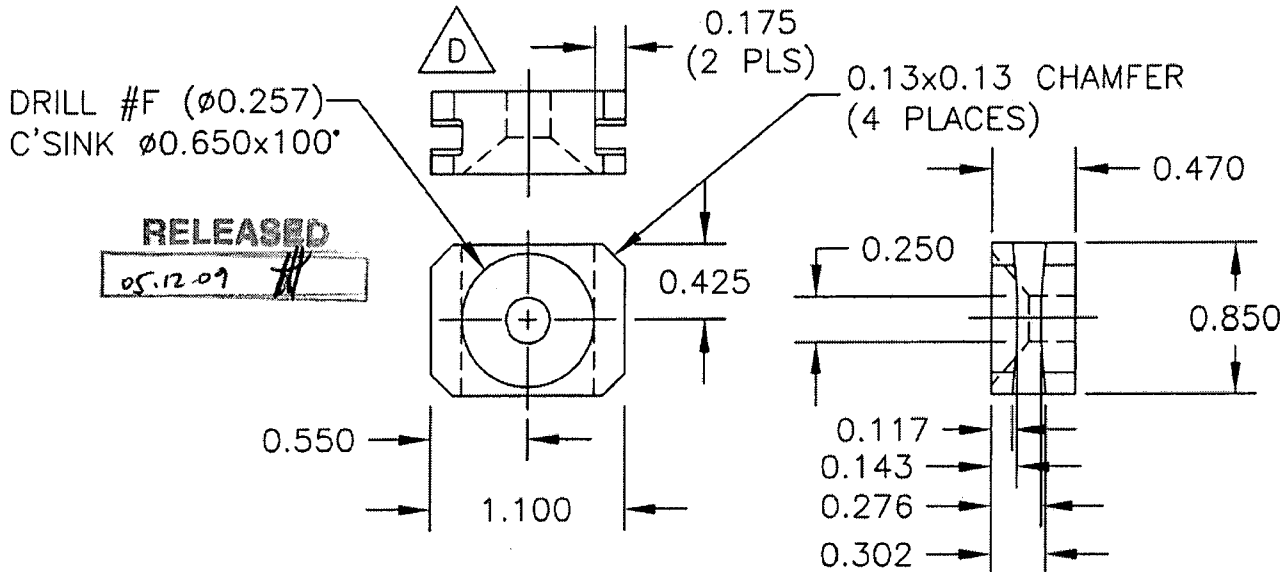
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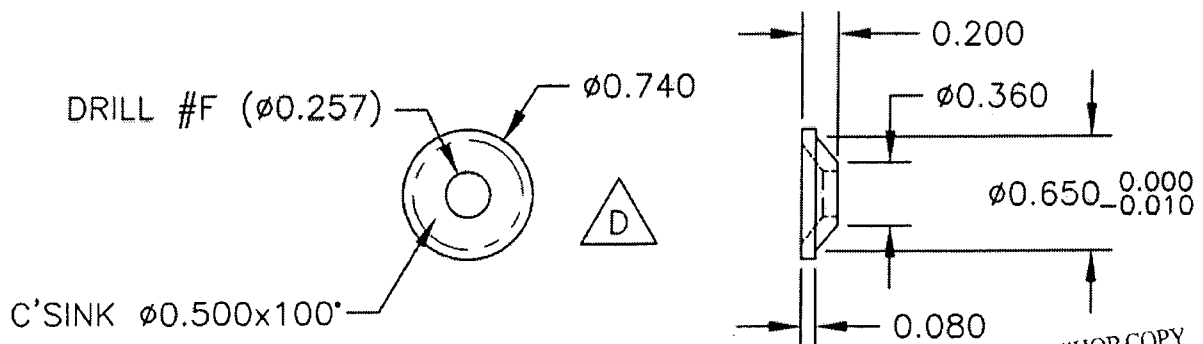
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CHECKED 	APPROVED 	DRAWING NO. D3137	REV. E SHEET 3 OF 5
DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3137-3 GUIDE**

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015

**D3137-5 WASHER**

- 1) REPLACES PREMIER P/N B30-23000-209
- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M6061T6R)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL EDGES 0.005 TO 0.015

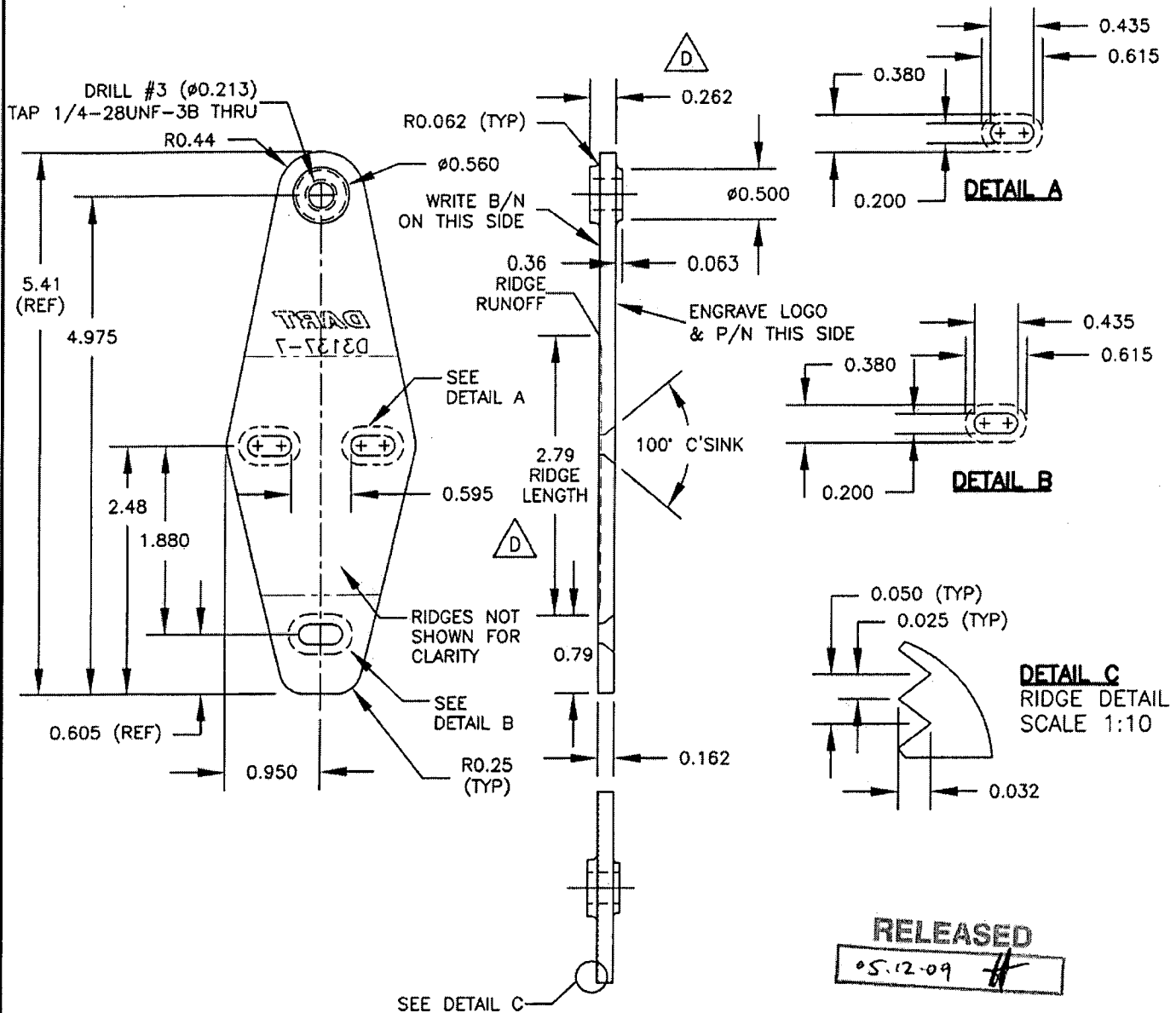
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DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 2:3

**Q3137-7 BRACKET:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 7) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

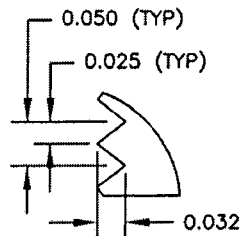
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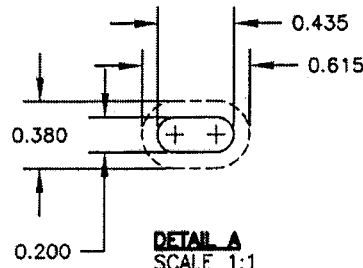
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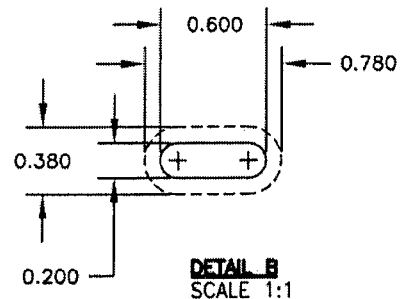
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DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 1:2



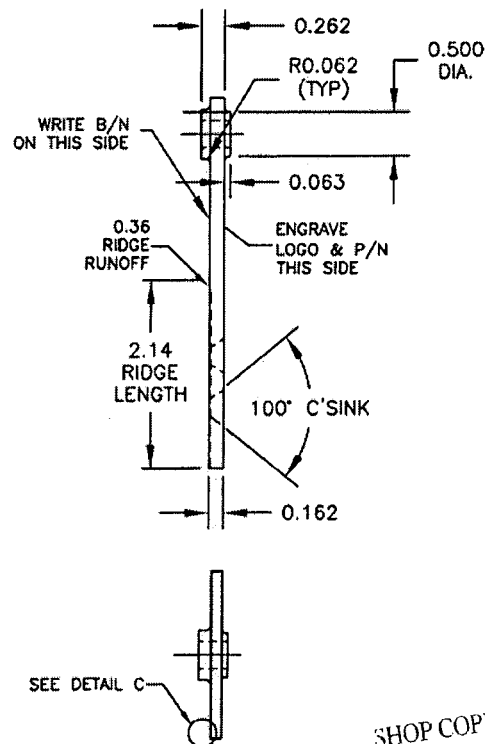
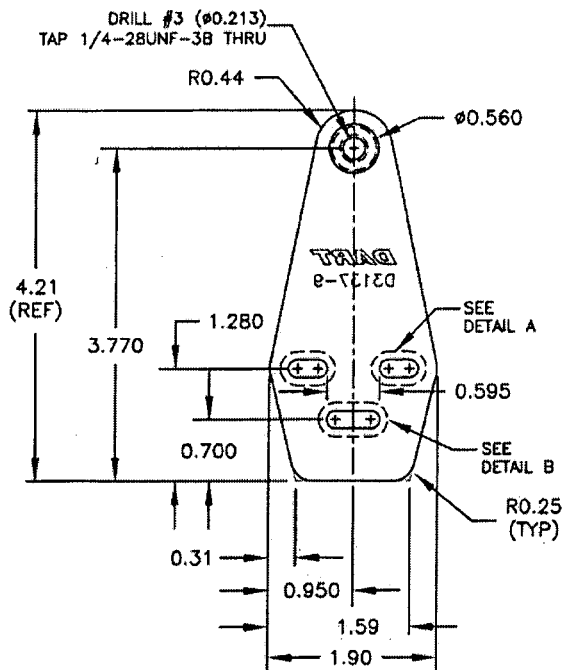
DETAIL C
RIDGE DETAIL
SCALE 1:20



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1



D3137-9 BRACKET:

- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
- 2) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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